

Work Order ID 71055

Tuesday, June 21, 2011 1:30:59 PM

BLUE



Page 1

Item ID: D206-628-022BL

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH, Blue

Stop



Start Date: 6/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D206-628	F

Pto →

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-022BL CHG 003

8 u108/0E

CLD Rev BL 11/09/27

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/7/28 S/ 20

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8 u108/0E

CLD

Dart Aerospace Ltd

W/O: 71055		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
u100/08	#100	Perm. change. ADD correct Amounts to vendor qty per kit the column.	N/A				S u100/08	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-022BL

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step RH, Blue

Start Date: 6/21/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 2.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging	Packaging	0.00							
Packaging	Memo Identify and pack for shipping as per PPP D206-628-022BL Location: _____ PPP Rev: <u>4</u>	0.00							
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/08/09
11/08/09
②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71055

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevF: add D2724-042 DD 09.11.17 verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-14A Bolt		Purchased	No				Each	167.0000	24	8			
-----------------	--	-----------	----	--	--	--	------	----------	----	---	--	--	--

Location	Loc Qty	Loc Code
ST357	167	
116914	4	
117619	13	
117872	150	

AN4-15A Bolt		Purchased	No				Each	291.0000	8	16			
-----------------	--	-----------	----	--	--	--	------	----------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST357	200	
117423	200	
ST358	91	
117872	91	

AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	0.0000	412	24			
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D2724-042 206L Step Assembly		Manufactured	No				Each	0.0000	2	2			
---------------------------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

206L Step Assembly

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 71055

Parent Item: D206-628-022BL

Parent Item Name: Heli-Access-Step RH, Blue

Start Date: 6/21/2011

Required Date: 7/5/2011

Start Qty: 2.00

Required Qty: 2.00

D2731-7 Manufactured No

Each 67.0000



Mounting Lug

Blue

Location

Loc Qty

Loc Code

ST470

67

62929

23

66427

32

69177

12

Each

16.0000

D2732-030

Manufactured No



Rubber Cushion

Qty x 8 per kit @ 3.04 Lbs

messured 51102/02

Location

Loc Qty

Loc Code

ST402

16

69205

16

Each

89.0000

D3394-043

Manufactured No



Lug Assembly

Blue

Location

Loc Qty

Loc Code

ST475

89

62930

12

62976

30

66429

34

69180

13

Each

4,805.000

MS21042L4

Purchased No



Nut

Location

Loc Qty

Loc Code

ST300

4805

117441

2511

117601

794

117885

1500

x4

8

(42)



B71083

16

B67283

x4

8

(2x)



B71082

B72520

11/3/3

5

24



11/7/28

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Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

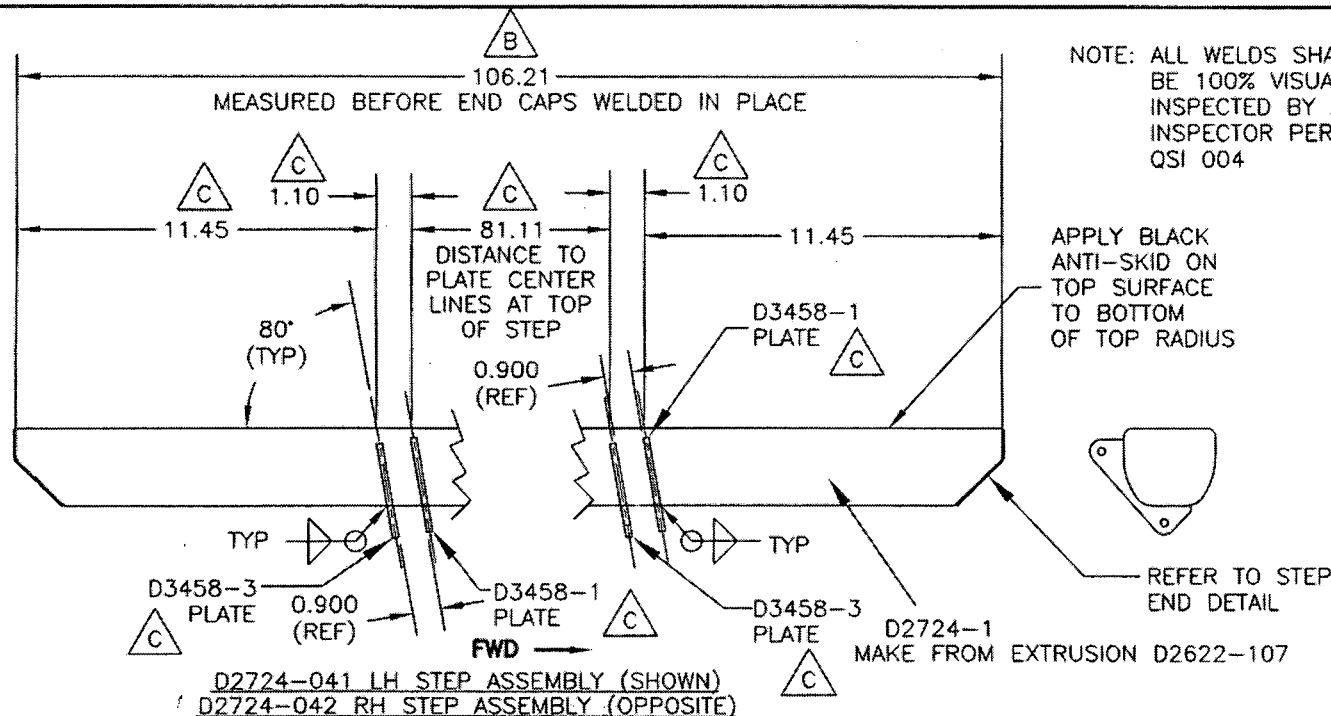
Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

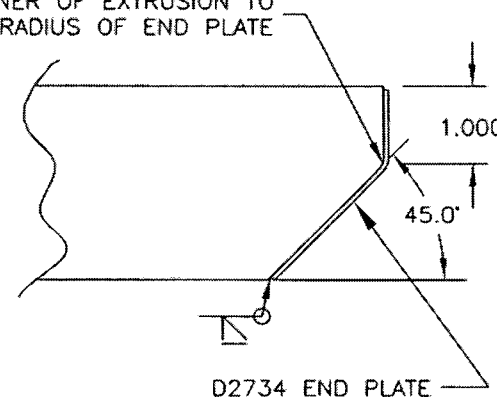
DART
REFERENCE

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.19	TITLE	D2724	RE-DESIGN, ADD D3458-1/-3
			206L/407 STEP ASSEMBLY	
			NEW ISSUE	
			UPDATED WELD DETAIL REVISED TOLERANCES	
			SCALE	
			NTS	
			SHEET 1 OF 1	
			REV. C	